



Dart Aerospace Ltd.
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D350-591-312
Job Sheet 181147



Part No: D350-591-312

Job Qty: 4 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No: NON AIRBUS CHG 2

Due Date: 8/8/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:c IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	8/8/18	8/8/18	0.00	0.00	Start Up Large Fab-4		CPC
110	Large Fab	4 pcs	8/8/18	8/8/18	0.00	4.00	Large Fab 2		SL4
120	QC	4 pcs	8/8/18	8/8/18	0.00	0.00	QC9		PD 13-05-01
130	QC	4 pcs	8/8/18	8/8/18	0.00	0.00	QC5		PD 13-05-01
140	HandFinish	4 pcs	8/8/18	8/8/18	0.00	0.75	HandFinish1		SA 18-08-02
150	QC	4 pcs	8/8/18	8/8/18	0.00	0.00	QC7-2		PD 13-05-07
180	Large Fab	4 pcs	8/8/18	8/8/18	0.00	4.00	Large Fab 2		SL4
190	QC	4 pcs	8/8/18	8/8/18	0.00	0.00	QC10		PD 13-05-11
200	QC	4 pcs	8/8/18	8/8/18	0.00	0.00	QC5		PD 13-05-17
210	HandFinish	4 pcs	8/8/18	8/8/18	0.00	0.75	HandFinish1		DR 18/08/17
220	Powdercoat	4 pcs	8/8/18	8/8/18	0.00	1.19	Powdercoat1		DR 18-8-01
230	HandFinish	4 pcs	8/8/18	8/8/18	0.00	0.75	HandFinish3		PPD 18-08-21
240	QC	4 pcs	8/8/18	8/8/18	0.00	0.00	QC3		AUG 21 2018
250	Packaging	4 pcs	8/8/18	8/8/18	0.00	0.00	Packaging1-3		SEP 20 2018
260	QC	4 pcs	8/8/18	8/8/18	0.00	0.00	QC4		SEP 20 2018
270	Packaging	4 pcs	8/8/18	8/8/18	0.00	0.00	Packaging3-1		SEP 20 2018
275	DC	4 pcs	8/8/18	8/8/18	0.00	0.00	DC		SEP 20 2018
280	QC21-FG	4 Ea	8/8/18	8/8/18	0.00	0.00	QC21		SEP 20 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6 Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 9:10 OVEN TEMPERATURE: 350° FINISH TIME: 9:10

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

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Container No: S097001



Part: D350-591-312

Job No: 181147

Serial No/Batch: S097001

Revision:

Inspector:

Exp Date:

Wingwalk S098/20

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	8 Ea (2 ea)	90-Start up Operation	5069554
D3219-1	Plate	8 Ea (2 ea)	90-Start up Operation	5083126
D3272-1	Step	4 Ea (1 ea)	90-Start up Operation	5095611
D3065-041	Step Leg Assembly	4 Ea (1 ea)	180-Large Fab	5095169
D3066-1	Spacer	8 Ea (2 ea)	180-Large Fab	5077435
MS20600-AD4W4	Rivet	64 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	8 Ea (2 ea)	250-Packaging	5089302
AN4-13A	Bolt	32 Ea (8 ea)	250-Packaging	5089302
AN5-36A	Bolt	8 Ea (2 ea)	250-Packaging	5071345
D2230-3	Mounting Lug	16 Ea (4 ea)	250-Packaging	5106786
D2618	Bushing	8 Ea (2 ea)	250-Packaging	5089996
D2856-400-720	Abrasion Strip 4" X 7.20"	8 Ea (2 ea)	250-Packaging	5102532
D3235-1	Mounting Lug	8 Ea (2 ea)	250-Packaging	510378
D3278-041	Support Assembly	4 Ea (1 ea)	250-Packaging	5106503
MS21042L3	Nut	8 Ea (2 ea)	250-Packaging	5089340
MS21042L4	Nut	32 Ea (8 ea)	250-Packaging	5089365
MS21042L5	Nut	8 Ea (2 ea)	250-Packaging	5083541
NAS1149D0363J	Washer	16 Ea (4 ea)	250-Packaging	5068061
NAS1149D0463J	Washer	64 Ea (16 ea)	250-Packaging	5089299
NAS1149D0563J	Washer	16 Ea (4 ea)	250-Packaging	5093723
DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	4 Ea (1 ea)	250-Packaging	5103492

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	8	173	0
	D3219-1	8	175	0
	D3272-1	4	0	0
180-Large Fab	D3065-041	4	23	0
	D3066-1	8	188	0
250-Packaging	MS20600-AD4W4	64	2,484	0
	AN3-35A	8	312	0
	AN4-13A	32	1,846	0
	AN5-36A	8	248	0
	D2230-3	16	111	0
	D2618	8	439	0
	D2856-400-720	8	124	0
	D3235-1	8	202	0
	D3278-041	4	58	0
	DSI 9410-011	4	10	0
	MS21042L3	8	4,669	0
	MS21042L4	32	6,750	0
	MS21042L5	8	1,202	0
	NAS1149D0363J	16	1,237	0
	NAS1149D0463J	64	11,200	0
	NAS1149D0563J	16	2,268	0

Part Specifications

Specifications could not be found.

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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